

Work Order ID 126537 -1

Thursday, November 13, 2014 8:35:09 AM

126537

Ship Nov. 21

Page 1

Item ID: D3779-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Handle Assembly (Exterior)

Stop *NS2*

Start Date: 11/17/14

Start Qty: 26.00

26

Required Date: 11/20/14

Req'd Qty: 26.00

26

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-11-12 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3779	C								

100

100

Waterjet

FLOW WATER JET

0.00

FLOW CNC Waterjet

6061 .125

Memo

0.00

1-Cut as per Dwg D3779-1

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

28

0

DAS
23
9-89

14-11-13

110

110

QC

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

Quality Control

28

0

DAS
23
9-89

14-11-13

120

120

QC

QC8- Inspect parts - second check

0.00

Memo

0.00

Quality Control

28

DAS
32
9-89

NOV 13 2014

Work Order ID 126537

Thursday, November 13, 2014 8:35:09 AM

126537

Page 2

Item ID: D3779-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Handle Assembly (Exterior)

Start Date: 11/17/14 Start Qty: 26.00

26

Cust Item ID:

Required Date: 11/20/14 Req'd Qty: 26.00

26

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Small Fab	0.00							
130									
Small Fab	Memo	0.00							
Small Fab	1- Counter sink holes as per dwg D3779 2- Deburr								
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150									
HandFinish	Memo	0.00							
Hand Finishing									

DAS
36
9-89DAS
38
9-89

NOV 17 2014

DAS
38
9-89

Work Order ID 126537***126537***

Page 3

Thursday, November 13, 2014 8:35:09 AM

Item ID: D3779-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Handle Assembly (Exterior)
Start Date: 11/17/14 Start Qty: 26.00 ***26*** Cust Item ID:
Required Date: 11/20/14 Req'd Qty: 26.00 ***26*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

QC7-Inspect Chemical Conversion Coat

0.00

160

QC

Memo

0.00

DAS
30
9-89

10

14/12/22

Quality Control

180

Small Fab

0.00

180

Small Fab

Memo

0.00

Small Fab

1- Rivet handle to D3779-1 plate as per dwg D3779 per QSI003

10 FF

JAN 06 2015

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

DAS
38
9-89

10

JAN 07 2015

Quality Control

Work Order ID 126537***126537***

Page 4

Thursday, November 13, 2014 8:35:09 AM

Item ID: D3779-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Handle Assembly (Exterior)
Start Date: 11/17/14 Start Qty: 26.00 ***26*** Cust Item ID:
Required Date: 11/20/14 Req'd Qty: 26.00 ***26*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Identify as per dwg & Stock Location: <u>4515</u>	0.00							
200									
Packaging	Memo	0.00							
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							
Quality Control									

MCS 15-01-07
WME 15-01-07

Picklist Print

Page 1

Thursday, November 13, 2014 8:35:14 AM

Work Order ID: 126537

126537

Parent Item: D3779-041

D3779-041

Parent Item Name: Handle Assembly (Exterior)

Start Date: 11/17/14

Required Date: 11/20/14

Start Qty: 26.00

Required Qty: 26.00

Comments: IPP Rev:A 08-06-09 new issue DD verified by:ec
IPP Rev:B 08-07-21 procedure change DD verified by:EC IPP Rev:C
11.12.02 as per dwg revB DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MG061T6S.125

Purchased

No

100

sf

149.3910

0.194

6

DAS

23

9-88

14-11-13

M6061T6S 125

6061-T6 .125 Sheet

**

Location

Loc Qty

Loc Code

MAT021

149.391

m127272

29.2

m127454

24.703

m127501

5.1

m128852

6.938

m130524

21.45

m130745

62

130745

D3779-7

Manufactured

No

180

Each

0.0000

1

26

**

FF

JAN 06 2015

D3779-7

Handle

MS20426AD10-9A

Purchased

No

180

Each

118.0000

4

104

**

B 126540

10 FF

14/12/22

MS20426AD10-9A

RIVET

Location

Loc Qty

Loc Code

ST311

130983

118

125170

1

M127659

17

M130862

100

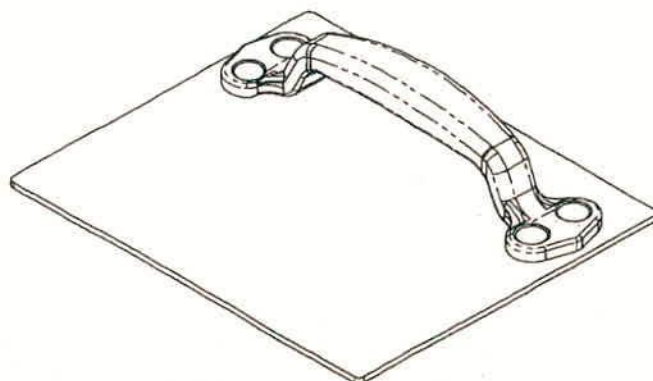
131200

38

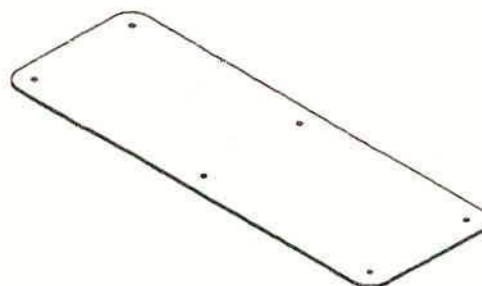
2

JAN 06 2015

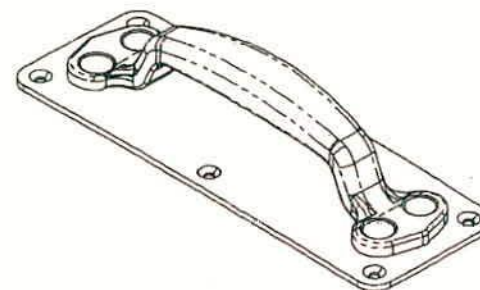
QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
X		D3779-041	HANDLE ASSEMBLY
	X	D3779-043	HANDLE ASSEMBLY
	1	D3203-1	HANDLE
1		D3779-1	PLATE
	1	D3779-5	PLATE
1		D3779-7	HANDLE
4	4	MS20426AD10-9A	RIVET, CSK



**D3779-043 HANDLE ASSEMBLY
(INTERIOR)**



D3779-3 DOUBLER PLATE



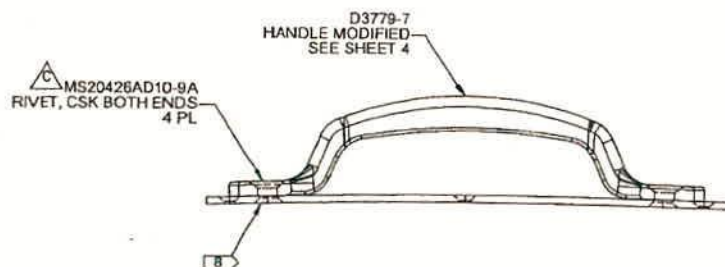
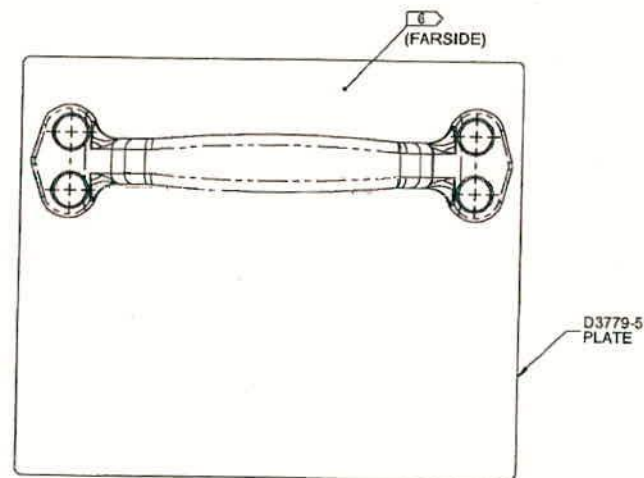
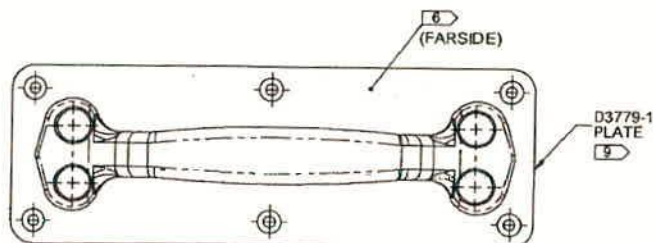
**D3779-041 HANDLE ASSEMBLY
(EXTERIOR)**

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: (SEE SHEETS 2 & 3)
 - 7) WEIGHT: D3779-3: 0.14 lbs
D3779-041: 0.71 lbs
D3779-043: 1.14 lbs

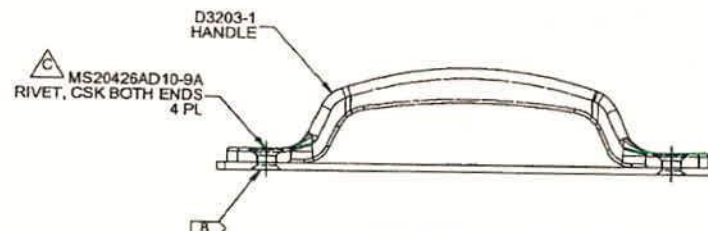
Handwritten: 126537

RELEASED
2012-07-23

C	CHANGED RIVET FROM -9 TO -9A CHANGED D3779-041 FROM FLAT TO CONTOURED	RP	12.04.26
B	REFORMAT IAW DART QSI 043, MS20426AD10-9 WAS MS20426AD10-8 (Z/N 06-1, 88/94-2) REASON: PRODUCTION FACILITY (PAR 11-136)	MB	11.11.24
A	NEW ISSUE	AJS	08.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	A.P.	DRAWING NO.	REV. C
MFG. APPR.	SA	D3779	SHEET 1 OF 4
APPROVED	SA	TITLE	SCALE
DE APPR.	SA	HANDLE ASSEMBLY, CABIN SLIDING DOOR	NTS
DATE	12.04.26	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL. NO REPRODUCTION OR DISSEMINATION OF THIS DOCUMENT IS PERMITTED WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	



**D3779-041 HANDLE ASSEMBLY
(EXTERIOR)**



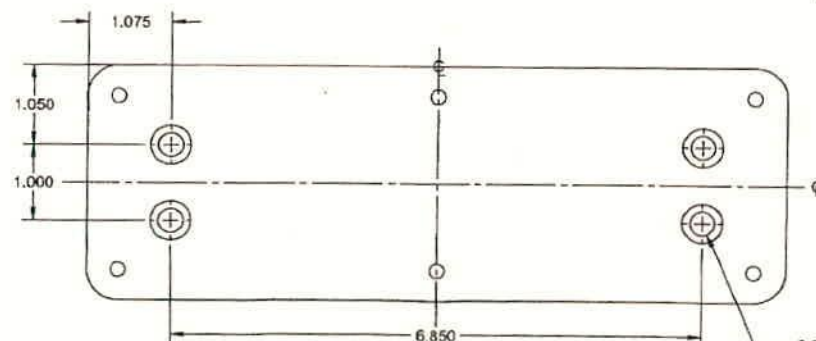
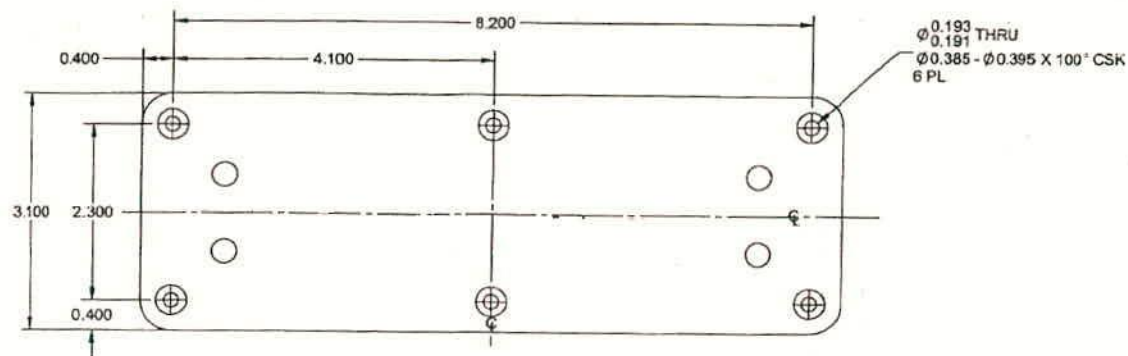
**D3779-043 HANDLE ASSEMBLY
(INTERIOR)**

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3779-XXX" AND B/N "BXXXX" PER DART QSI 044 6.1
- 7) WEIGHT: D3779-041: 0.71 lbs
D3779-043: 1.14 lbs
- 8) RIVETS TO BE PEENED AND GROUND FLUSH
- 9) FORMED TO FIT D3779-7 HANDLE DURING ASSEMBLY.

RELEASED
2012-07-23

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	AP	DRAWING NO. D3779	REV. C
MFG. APPR.	EP	SHEET 2 OF 4	
APPROVED	AM	TITLE	SCALE
DE APPR.	AM	HANDLE ASSEMBLY, CABIN SLIDING DOOR	
DATE	12.04.26	NTS	



D3779-1 PLATE

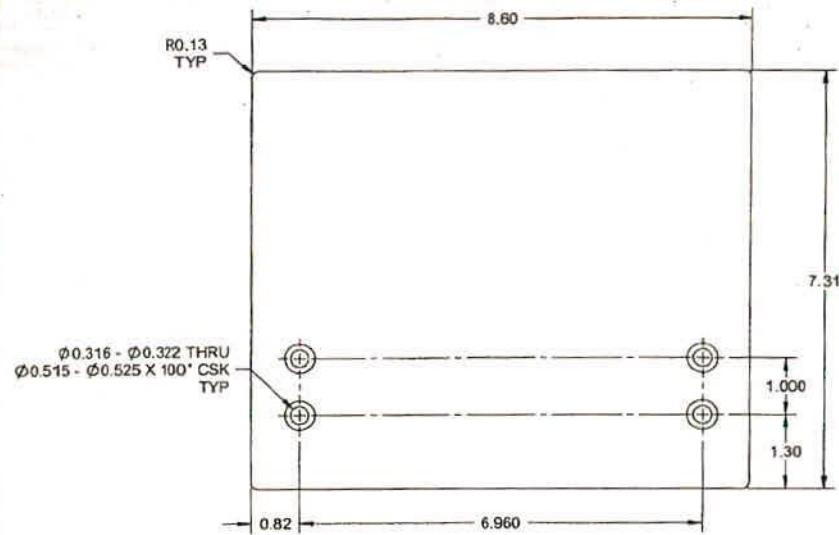
Ø 0.322 THRU
Ø 0.316 THRU
Ø 0.515 - Ø 0.525 X 100° CSK
4 PL

NOTES:

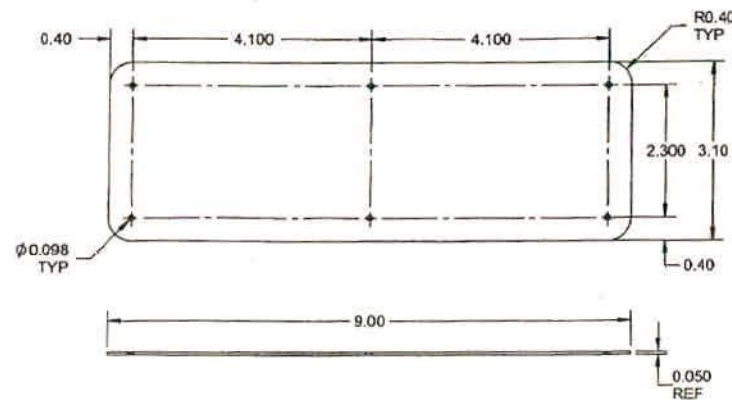
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK
PER AMS-QQ-A-250/11 OR AMS 4027
(REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.33 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. C
MFG. APPR.	E.O.	D3779	SHEET 3 OF 4
APPROVED	W.	TITLE	HANDLE ASSEMBLY, SCALE
DE APPR.	W.	CABIN SLIDING DOOR	NTS
DATE	12.04.26	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PREPARED AND CONTAINED IN THE CONFIDENTIALITY OF DART AEROSPACE LTD. IT IS NOT TO BE USED FOR ANY PURPOSE OR REPRODUCED IN ANY FORM WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

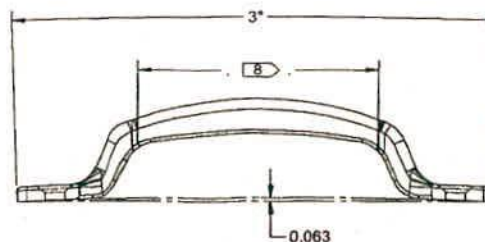
RELEASED
2012-07-23
N/A



D3779-5 PLATE



D3779-3 DOUBLER PLATE



D3779-7 HANDLE, MODIFIED

NOTES:

1) MATERIAL:

D3779-3: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF DART SPEC M6061T6S.050)

D3779-5: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK
PER AMS-QQ-A-250/11 OR AMS 4027
(REF DART SPEC M6061T6S.125)

D3779-7: MADE FROM D3203-1

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: D3779-3: IDENTIFY WITH DART PIN "D3779-3" AND B/N "BXXXXX" PER DART QSI 044 6.1

△ D3779-5: NONE
△ D3779-7: NONE

7) WEIGHT: D3779-3: 0.14 lbs

D3779-5: 0.76 lbs

D3779-7: 0.38 lbs

8) BEND HANDLE THROUGH THIS AREA ONLY △

RELEASED
2012-07-23

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	A.P.	DRAWING NO.	REV. C
MFG. APPR.		D3779	SHEET 4 OF 4
APPROVED		TITLE	HANDLE ASSEMBLY, SCALE
DE APPR.		CABIN SLIDING DOOR	NTS
DATE	12.04.26	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND CONTAINS NO INFORMATION THAT IS NOT TO BE RELEASED FOR ANY PURPOSE OR DISCLOSED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD	